



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW7105G00131-3G
Job Sheet 183991



Part No: RBW7105G00131-3G

Job Qty: 2 ea

Part Name: Engine Transport Stand



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/1/18

Job Tracking No:

Due Date: 12/17/18

Created By: Patrick Lussier

Type: Stock

Description:

Note: DWG.RBW7105G00131-3G Rev.6 IPP Rev A 17.11.02 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	2 pcs	12/17/18	12/17/18	0.00	0.00	Purchasing		JAN 04 2019
110	Packaging	2 pcs	12/17/18	12/17/18	0.00	0.00	Packaging2		JAN 04 2019
120	QC	2 pcs	12/17/18	12/17/18	0.00	0.00	QC6		JAN 04 2019
121	Small Fab	2 pcs	12/17/18	12/17/18	0.00	0.67	Small Fab-9		M.L.C. DAS 9-89
130	Packaging	2 pcs	12/17/18	12/17/18	0.00	0.00	Packaging3		DAS 28 9-89
140	QC21-FG	2 Ea	12/17/18	12/17/18	0.00	0.00	QC21		JAN 07 2019

Part Op 100 - Issue P/O: 041199 MANUFACTURE RBW7105G00131-3G AS PER DWG Supplier: METEC Certificate of Descriptions: conformity is required

121 - 1-Engrave placard RB41011 using marktronic engraver as per Dart QSI 044 2-Transfer drill Dart placard RB41011 using 29/32 drill. 3-Deburr holes. 4-Install Dart placard using drive screws as per DWG.

act 01 x 2 R h

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBW7105G00131-3GP	Engine Transport Stand	2 pcs (1 ea)	100-Purchasing	5141843
90051A077	Drive screws	8 pcs (4 ea)		5048890

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBW7105G00131-3GP	2	0	0

Part Specifications

Specifications could not be found.



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Plex 10/1/18 11:31 AM dart.Lussier.Patrick

Container No: S141844



Part: RBW7105G00131-3G

Job No: 183991

Serial No/Batch: S141844

Revision: 6

Inspector:

Exp Date:

Instructions:

Date: 01/04/19

ASSY QTY	ASSY QTY	ASSY QTY	ASSY QTY	ASSY QTY	ASSY QTY	B/O	Part #	UNIT	Description	Material	B/O INFORMATION OR SPECIFICATIONS	Pg.
						X	-01	1	ENGINE STAND ASSEMBLY			2
					X	1	-03		BOTTOM WELDMENT			3
							-05	2	SIDE TUBE	STEEL SQ. TUBE		4
							-07	2	END TUBE	STEEL SQ. TUBE		5
							-09	1	CENTER TUBE	STEEL SQ. TUBE		6
							-13	2	GUSSET PLATE	A36/1018/1020 HR		7
							-14	2	GUSSET PLATE	A36/1018/1020 HR		8
							-15	6	CENTER PLATE	A36/1018/1020 HR		9
							-17	4	WHEEL PLATE	A36/1018/1020 HR		10
							-18	1	PLATE	A36/1018/1020 HR		11
					X		-19	1	FRONT VERT. WELDMENT			12
							-21	1	FRONT VERT. SUPPORT	STEEL SQ. TUBE		13
							-23	2	GUSSET TUBE	STEEL SQ. TUBE		14
							-25	2	GUSSET PLATE	A36/1018/1020 HR		15
							-26	2	GUSSET PLATE	A36/1018/1020 HR		16
							-27	1	TOP MOUNT	A36/1018/1020 HR		17
							-28	1	BOLT HOLDER	A36/1018/1020 HR		18
					X		-29	2	REAR VERT. WELDMENT			19
							-31	1	REAR VERT. SUPPORT	STEEL SQ. TUBE		20
							-33	1	BRACE TUBE	STEEL SQ. TUBE		21
							-36	1	BOLT HOLDER	A36/1018/1020 HR		22
					X		-37	1	FRONT ENGINE MOUNT ASSEMBLY			23
							-39		FRONT WELDMENT			24
							-41		BASE	A36/1018/1020 HR		25
							-43		FRONT VERT. MOUNT	A36/1018/1020 HR		26
							-45		FRONT MOTOR MOUNT	1018/1020 CR		27
							B/O -47		BALL LOCK PIN	SS	Ø3/8 X 1-1/4 (MCMMASTER-CARR #90302A368)	23, 28
							B/O -49		LANYARD	COATED STEEL	Ø1/16 X 14 (CARR LANE #CL2C)	23, 28
							B/O -51		FERRULE	ALUMINUM	Ø1/16 X 3/8 (MCMMASTER-CARR #3896T31)	23, 28
					X		-53	2	REAR ENGINE MOUNT ASSEMBLY			28
							-55		REAR WELDMENT			29
							-57		BASE	A36/1018/1020 HR		30
							-59		REAR VERT. MOUNT	A36/1018/1020 HR		31
							-61		REAR MOTOR MOUNT	1018/1020 CR		32
							B/O -63	2	SWIVEL CASTER W/ BRAKES	HARD RUBBER	Ø5 WHEEL (BASSICK #CAS0156YZ-HDR51 (KK)-TLB)	2
							B/O -65	2	RIGID CASTER WHEEL	HARD RUBBER	Ø5 (BASSICK #CAS0156YZ-HDR51 (KK)	2
							B/O -67	12	HEX HEAD CAP SCREW	STEEL	5/16-24 X 7/8, GRADE 8 (MCMMASTER-CARR #92630A610)	2
							B/O -69	24	FLAT WASHER	STEEL	Ø5/16 (MCMMASTER-CARR #90126A030)	2
							B/O -71	3	HEX HEAD CAP SCREW	STEEL	1/4-28 X 21/32 AN4-5A	2
							B/O -73	11	FLAT WASHER	STEEL	Ø1/4 AN960-416	2
							B/O -75	8	HEX HEAD CAP SCREW	STEEL	3/8-24 X 45/64 AN6-6A	2
							B/O -77	8	FLAT WASHER	STEEL	Ø3/8 AN960-616	2
							B/O -79	16	HEX HEAD CAP SCREW	STEEL	3/8-16 X 5/8, GRADE 5 (MCMMASTER-CARR #92865A421)	2
							B/O -81	16	SPLIT LOCK WASHER	STEEL	Ø3/8 (MCMMASTER-CARR #91102A760)	2
							B/O -83	6	HEX HEAD CAP SCREW	STEEL	5/16-18 X 21/2, GRADE 5 (MCMMASTER-CARR #91247A593)	2
							B/O -85	6	NYLON LOCK NUT	STEEL	5/16-18, GRADE 5 (MCMMASTER-CARR #95615A160)	2

Isometric view of a four-wheeled mobile cart. The cart has a rectangular frame with a central vertical support structure. The support structure consists of two vertical posts connected by a horizontal bar. The front and rear of the cart are equipped with casters. The side rails are connected to the central support structure by diagonal braces. The entire assembly is mounted on a base plate.

DWG NO.		RBW7105G00131-3G		REV 6	
MATERIAL HEAT TREAT FINISH SPEC		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES FRACTIONS = 1/8 .XXX = .005 .XX = .01 .X = .015 SURFACES = 125/			
DRAWN BY:		1. BREAK ALL SHARP EDGES .015 X .005 OR .015 R 2. DIMENSIONAL LINES APPLY AFTER PLATING 3. SURFACES DIM AND TOL PER ASME Y14.5M-2009			
CHECKED:		USED ON MODEL			
OPPS APPR:		A/W139			
QA APPR:					
APPROVED:					
SCALE		DATE		SHEET 1 OF 33	
1:14		2/24/2010			



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041199**

Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

Attention: Walz, Shigi

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO041199
PO Date: 10/1/18
Due Date: 12/17/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments:

Revision

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	183987	RBW6205G00632-3GP			Sling, Main Rotor Blade Lift As per Dwg RBW6205G00632-3G Rev. 6	Firmed	-	12/17/18	3 pcs	0 pcs	3 pcs	\$6,548.85/pcs	\$19,646.55
Line Item Note: SIOP													
2	183988	RBW6205G11532-3GP			Swashplate Support Stand As Per Dwg RBW6205G11532-3G REV 5	Firmed	-	12/17/18	2 pcs	0 pcs	2 pcs	\$8,811.00/pcs	\$17,622.00
Line Item Note: SIOP													
3	183990	RBW7105G00231-3GP			Engine Lifting Tool As Per Dwg RBW7105G00231-3G Rev. 10	Firmed	-	12/17/18	2 pcs	0 pcs	2 pcs	\$2,879.00/pcs	\$5,758.00
Line Item Note: SIOP													
4	183991	RBW7105G00131-3GP			Engine Transport Stand As Per Dwg RBW7105G00131-3G Rev. 6	Firmed	-	12/17/18	2 pcs	0 pcs	2 pcs	\$4,717.00/pcs	\$9,434.00
Line Item Note: SIOP													
												Grand Total:	\$52,460.55



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Tel (613) 632-5200

PURCHASE ORDER PO041199

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY
A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION
A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
A049 SUPPLIER AWARENESS

Plex 10/1/18 11:58 AM dart.Lussier.Patrick



METAL TECHNOLOGY INC.

www.metec.ca | 20 Terry Fox Drive, Vankleek Hill, Ontario, Canada K0B 1R0 | Phone: +1 613-678-3957 Fax: +1 613-678-3956

Packing List

Bill Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Ship Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Att. Patrick Lussier

Shipment No: 24476
Shipment Date: 03-Jan-2019
Ship Via: Pick up at METEC
Order Number: 3064
Order Date: 10/01/18

Customer Code: DART
Phone: (613) 632-9577
PO Number: PO041199 R3
Terms: Net 60 Days

----- Quantity -----								
<u>Item</u>	<u>Open</u>	<u>Shipped</u>	<u>B/O</u>	<u>Canceled</u>	<u>Unit</u>	<u>Description</u>	<u>Revision</u>	<u>Job Number</u>
4	2	2	0	0	EA	DART-RBW7105G00131-3GP Engine Transport Stand, drawing # RBW7105G00131-3G Rev.6	6	3064-04

The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.

Packing Clerk's Signature
Metec Metal Technology Inc

Received In Good Order By
Att. Patrick Lussier

Page 1 of 1



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

Quantity	Part Number	Part Name	Dwg Rev#	P.O. Number
2	RBW7105G00131-3G	Engine Transport Stand	6	PO041199 R3
		Deviation see Mike Lee		
		Material supplied by METEC		

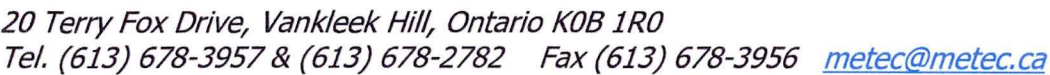
We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


George Théoret

Vankleek Hill, January 3, 2019

DAS
68
9-89



SOLD TO:

SHIPPED TO:

same

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


George Théoret

Vankleek Hill, January 3, 2019

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

Work Order update only ☐

Work Order: _____ Part No. <u>RBW7105G00131-3G Rev. 6</u> NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date : _____		Step #: _____		QTY Effective : _____		MRB (QSI042) Approval Jan 3, 2019																			
Description Work Order Deviation				Disposition																					
RBW7105G00131-3G-45 has been manufactured from 304 Stainless Steel as an alternative material Zinc Plate is not required				- This deviation is acceptable. - The fit, form and function of the part will be as originally intended.																					
				Completed By																					
				Lead hand / Supervisor Approval Verification																					
				QC / QA Coordinator Approval																					

Root Cause			FAULT CATEGORY			
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	☒	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	☐	Manufacturing Process ☐				
Misidentified ☐	☐	Past Due ☐	OTHER : _____			